Work Order ID 97308

February-14-13 1:46:36 PM

97308

Item ID: D3395-1 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bushing

Start Date: 2/14/13 **Start Qty:** 30.00 *30*

Required Date: 3/01/13 **Req'd Qty:** 30.00 *30*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** RP **Date:** 13-02-19 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3395	Rev A								
100		0.00							
100	Hardinge CNC LATHE SMALL					30	Ø		
Hardinge	**Memo**	0.00	PO	13/02/24					
Hardinge CNC Lathe Small	Turn as per Folio FA513 and Dwg D3395Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						30	Ø		
QC	**Memo**	0.00	PO	13/02/24					
Quality Control									
120	QC8- Inspect parts - second check	0.00	RP	13.2.25		30	d		
120									
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 97308

97308

February-14-13 1:46:36 PM

Item ID: D3395-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bushing

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Required Date: 3/01/13 **Req'd Qty:** 30.00 *30*

Reference:

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Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: SOQ	0.00				30			SP 13-2-25
130									
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							13/2/26
140									
QC	**Memo**	0.00							
Quality Control									

MF

13-2-26

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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- Work Order Update ☐

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- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
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- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

February-14-13 10:56:28 AM

Work Order ID: 97308

Parent Item: D3395-1

Parent Item Name: Bushing

Start Date: 2/14/13 **Required Date:** 3/01/13

Start Qty: 30.00 **Required Qty:** 30.00

Comments: IPP A05.02.23New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.500 Delrin Round Bar .50"		Purchased	No			100	f	137.1730	0.0625	1.973685	PO	13/02/24	

Location	Loc Qty	Loc Code	
MAT018	137.173		
109571	6.82		
→ 123698	40.833		1.98
18355	89.52		

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
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- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

DART AEROSPACE LTD	Work Order:	97308
Description: Bushing	Part Number:	D3395-1
Inspection Dwg: D3395 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	.603	✓		VERN	P40-01
0.060	+/-0.010	.063	✓		"	"
R0.010	+/-0.010	.010	✓		"	"
0.030 x 20°	0.5°	.030 X20°	✓		"	"
Ø0.500	+/-0.010	.498	✓		"	"
Ø0.191	+0.005/-0.001	.192	✓		"	"
Ø0.305	+/-0.010	.305	✓		"	"

Measured by:	RO
Date:	13/02/24

Audited by:	ZP
Date:	13-2-25

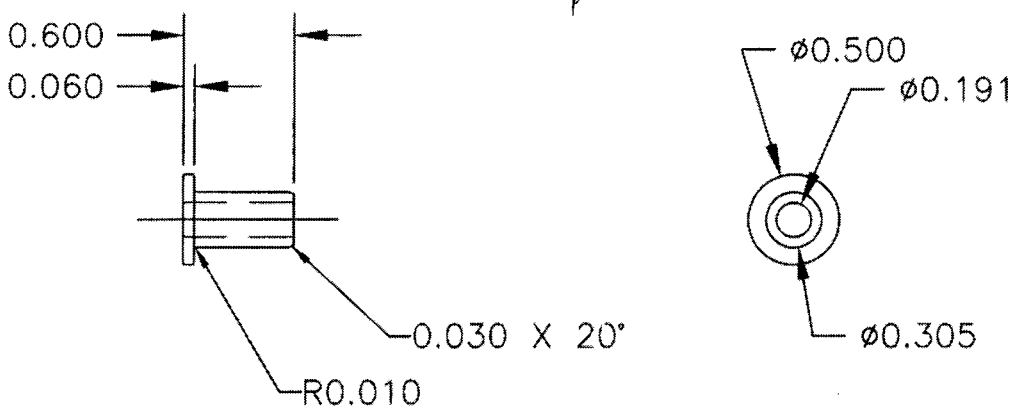
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.0714	New Issue	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP		
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3395	SHEET 1 OF 1
DATE		TITLE	SCALE
05.03.10		BUSHING	1:1
A	05.03.10	NEW ISSUE	

RELEASED
05.03.11

97308
Ø13-02-1C



D3395-1 BUSHING

1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
2) FINISH: NONE
3) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

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